

Date: Monday, 7/9/2007 11:38:38 AM  
 User: Kim Johnston

## Process Sheet

①

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE  
 Job Number : 33317  
 Estimate Number : 12925  
 P.O. Number : N/A Part Number : D29331UP  
 This Issue : 7/9/2007 S.O. No. : N/A Drawing Number : D2933 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : N/A Material : N/A  
 Due Date : 7/27/2007 Qty: 8 Um: Each  
 Written By :  
 Checked & Approved By : J.F. 07.07.09  
 Comment : Est Rev: A New Issue 07-07-04 JLM

## Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: B 31386

J.F. 07/07/28

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

J.F. 07/07/30

⑧

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.F. 07/07/30

⑧

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/07/30

⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/08/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:38:38 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 33317

Part Number: D29331UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.07.30

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SA

07-07-31

(8)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

N/A

Noted

Un Painted.

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/8/2

(8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/03

Job Completion



07.08.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 33317
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2933-1
<b>Inspection Dwg:</b> D2933 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		123"	120"	120"	121"		
B	0.100	0.140		121"	120"	118"	120"		
C	0.100	0.140		114"	120"	120"	121"		
D	0.210	0.230		221"	221"	220"	219"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
H	0.510	0.515		512"	512"	512"	512"		
I	1.572	1.582		1.578"	1.578"	1.578"	1.578"		
J	2.495	2.505		2.501"	2.501"	2.501"	2.501"		
K	0.257	0.262		0.258"	0.258"	0.258"	0.258"		
L	0.312	0.317		0.314"	0.314"	0.314"	0.314"		
M	0.235	0.240		0.235"	0.239"	0.239"	0.239"		
N	0.100	0.140		114"	121"	119"	118"		
O	0.540	0.560		550"	551"	550"	551"		
P	0.490	0.510		503"	503"	502"	502"		
Q	3.715	3.725		3.721"	3.721"	3.721"	3.721"		
R	2.470	2.510		2.496"	2.496"	2.496"	2.496"		
S	0.240	0.270		249"	248"	246"	250"		
T	0.100	0.180		130"	130"	130"	130"		
U	1.625	1.635		1.630"	1.630"	1.630"	1.630"		
V	1.362	1.372		1.369"	1.369"	1.369"	1.369"		
W	0.316	0.321		0.319"	0.319"	0.319"	0.319"		
X	1.125	1.145		1.135"	1.137"	1.138"	1.132"		
Y	1.565	1.585	DT8695 A/B	1.575"	1.575"	1.575"	1.575"		
Z	0.178	0.198		0.188"	0.188"	0.188"	0.188"		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J.F.	Audited by: S.A.
Date: 07/07/29	Date: 01.01.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	

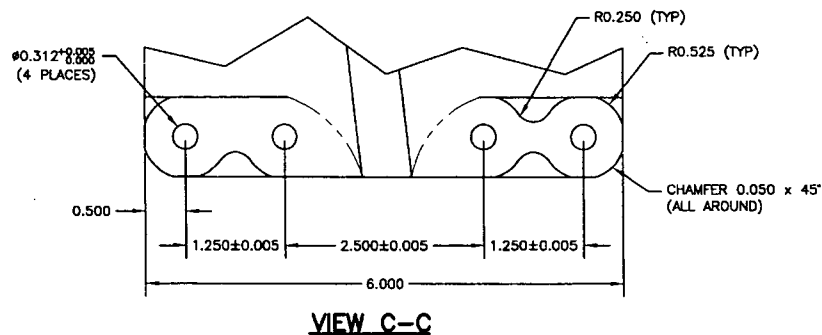
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>33317</b>
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	<b>D2933-1</b>
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B	0.100	0.140		.121"	.121"	.120"	.120"		
C	0.100	0.140		.122"	.118"	.116"	.117"		
D	0.210	0.230		.219"	.219"	.219"	.220"		
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AA									
AB									
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AE									
AF									
Accept/Reject									

Measured by: <b>J.F.</b>	Audited by: <b>SA</b>
Date: <b>07/07/29</b>	Date: <b>07.01.30</b>

Rev	Date	Change	Revised by	Approved
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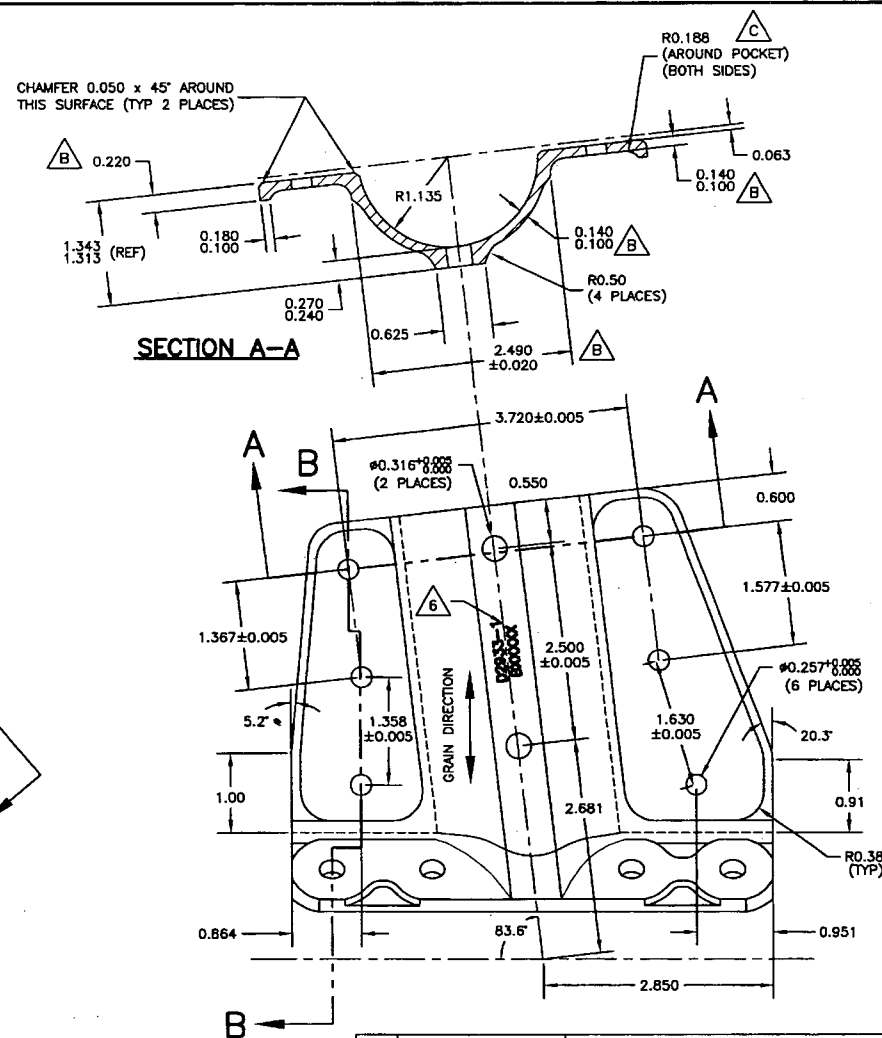
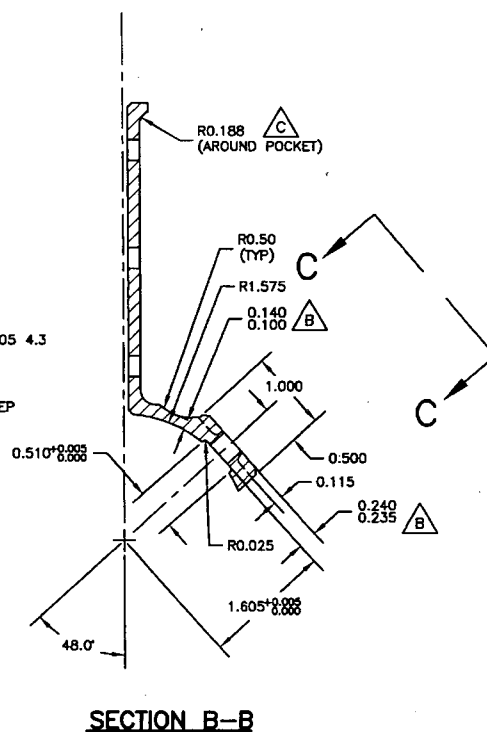
**D2933-1 LH SADDLE (SHOWN)**  
**D2933-2 RH SADDLE (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 33317

07.02.12



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART AEROSPACE USA, INC.
CHECKED	PH	D2933
DATE	06.11.09	SADDLE INSIDE

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DART AEROSPACE USA, INC.

REV. C

SHEET 1 OF 1

SCALE

2:3